

Work Order ID 67715

Tuesday, March 29, 2011 1:22:34 PM



April 4/5

Page 1

Item ID: D4150-1

Accept



Setup Start



Revision ID:

Item Name: Arm

Stop



Start Date: 3/29/2011 Start Qty: 6.00

Required Date: 4/5/2011 Req'd Qty: 6.00

12.0
4/5



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan: MC

Date: 11-03-29

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4150

B

100

Cut blanks as per folio

0.00



Bandsaw

Memo

0.00

Jeaspa Bandsaw

3.950" LONG

4/5/12

12

0

110

0.00



HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

MACHINE AS PER FOLI FA943 AND DWG

FOLIO REV: AA

DWG REV: B

11/04/04

12

0

DEBURR

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Item Name: Arm

Start Date: 3/29/2011 Start Qty: 6.00

Required Date: 4/5/2011 Req'd Qty: 6.00

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

- H.A 11/04/04

12

φ

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

SL 11/04/04

(12)

170

Identify as per dwg & Stock Location

0.00



Packaging

Memo

0.00

Packaging

11/4/14 φ (12)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

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Item ID: D4150-1

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Setup Start



Revision ID:

Stop



Item Name: Arm

Start Date: 3/29/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 4/5/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/4/5

ME

11-04-05

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

Tuesday, March 29, 2011 1:22:30 PM

Page 1

Work Order ID: 67715

Parent Item: D4150-1

Parent Item Name: Arm



Start Date: 3/29/2011

Required Date: 4/5/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A 10.06.24 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M303B0.750X1.500 		Purchased	No			100	f	32.0000	0.333333	1.999998		11/04/04	
303 BAR .750" X 1.500"													

Location

Loc Qty

Loc Code

MAT050

32

— 114968

20

115047

12

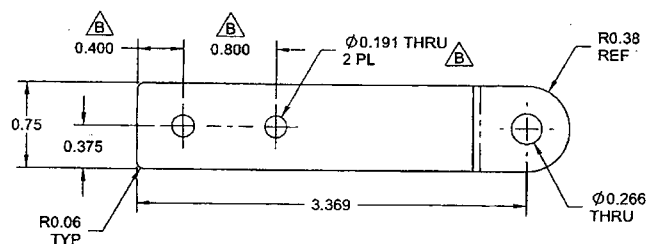
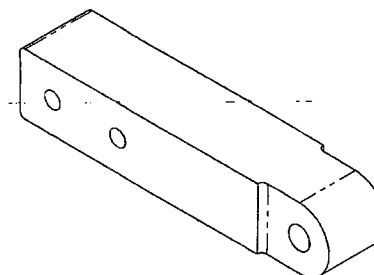
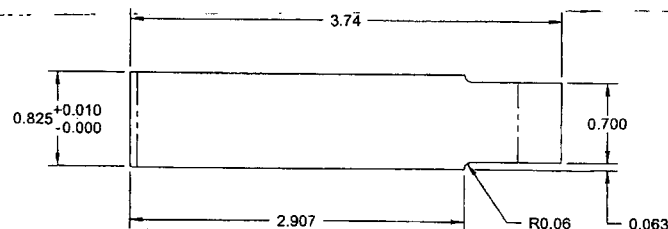
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NOTE: Date & initial all entries



#67715

D4150-1 ARM

RELEASED
2010-07-16
MD

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL BAR PER ASTM A582 OR ASTM A276
REF DART SPEC M304B OR M303B
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.60 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4150	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		ATTACHMENT ARM ASSY	NTS
DATE	10.07.08	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR DISCLOSED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

W/O:		WORK ORDER CHANGES						
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DART AEROSPACE LTD		Work Order: 67715
Description: ARM		Part Number: D4050-1
Inspection Dwg: D4150 , Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒

First Article

☒

Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.74	+/- .030	3.751	✓		Vern	GA-01
0.825	+ .010 / - 0.000	0.829	✓		"	"
2.907	+/- .010	2.905	✓		"	"
R0.06	+/- .030	R0.063	✓		R-6	ref.
0.063	+/- .010	0.063	✓		Vern	GA-01
R0.38	+/- .030	R0.375	✓		R-6	ref.
φ 0.191	+ .005 / - .001	φ 0.192	✓		VERN	GA-01
0.800	+/- .010	0.800	✓		"	"
0.400	+/- .010	0.402	✓		"	"
0.75	+/- .030	0.743	✓		"	"
0.375	+/- .010	0.372	✓		"	"
R0.06	+/- .030	R0.063	✓		R-6	ref.
3.369	+/- .010	3.368	✓		Vern	GA-01
φ 0.266	+ .006 / - .001	φ 0.269	✓		"	"
0.700	+/- .010	0.705	✓		"	"

Measured by: B. A.	Audited by: <i>[Signature]</i>	Prototype Approval:
Date: 11/04/04	Date: 11/04/04	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	